

Work Order ID 58040

Thursday, April 22, 2010 10:31:45 AM



Page 1

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 4/22/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 4/23/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: YMF

Date: 10-4-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4034

A

100

Weld per dwg A/R S.S. rod Batch: 1113328 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564 ✓

2- Weld bushing in rib as per dwg ✓

SY 10/04/26 (3x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

(5) 10.04.27

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

Scolobut27

(45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: *CWA*

0.00

Memo

0.00

*SAD**10-04-27**(5)*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/04/28**BT 10-4-28*

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Picklist Print

Thursday, April 22, 2010 10:31:44 AM

Page 1

Work Order ID: 58040

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC





IPP Rev:B as

Start Date: 4/22/2010

Required Date: 4/23/2010

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D4034-1 		Manufactured	No			100	Each	0.0000	5.0000			
✓ Rib D4034-5 		Manufactured	No			100	Each	0.0000	5.0000			
✓ Rib D2327-3 		Manufactured	No			100	Each	31.0000	5.0000			
Spacer Bushing												
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>WA</div> <div>57186</div> <div>57790</div> </div> <div> <div>Loc Qty</div> <div>31</div> <div>11</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
* D4021-7 		Manufactured	No			100	Each	0.0000	5.0000			
Hoop												

B58037 ⑤ 10/04/26

B58038 ⑤ 10/04/26

10/04/26

5x

B58039 ⑤ 10/04/26

W/O:		WORK ORDER CHANGES					
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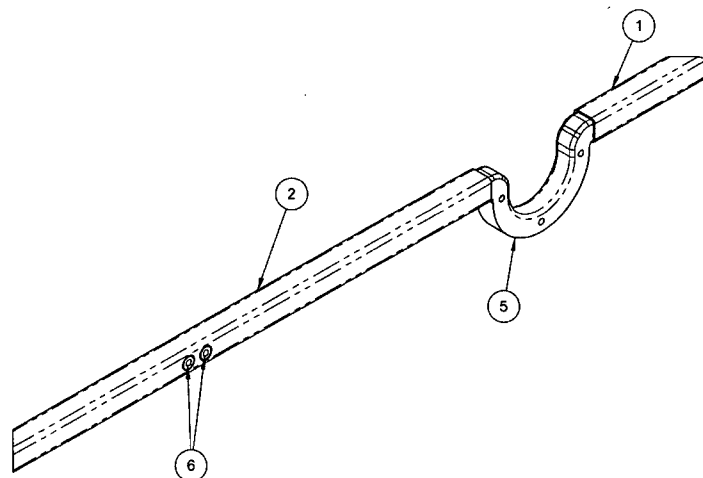
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

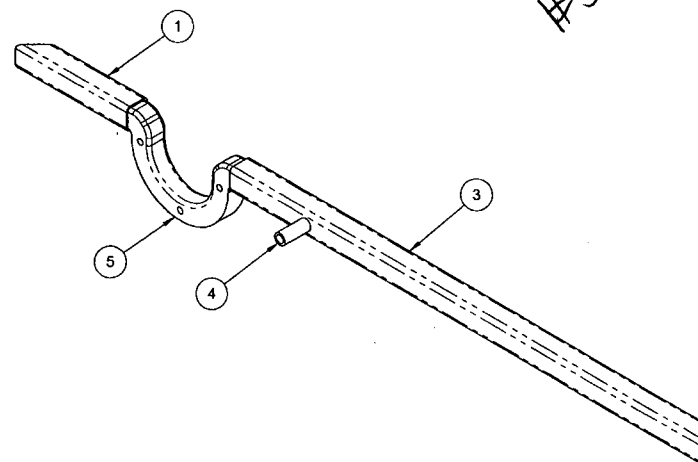
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

#58040

RELEASED
2010-03-12
JMP

A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	JP		
MFG. APPR.	E		
APPROVED	MP		
DE APPR.	MP		
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4034**
REV. A
SHEET 1 OF 4
TITLE
UPPER RIB ASSY, BASKET BASE
SCALE
NTS
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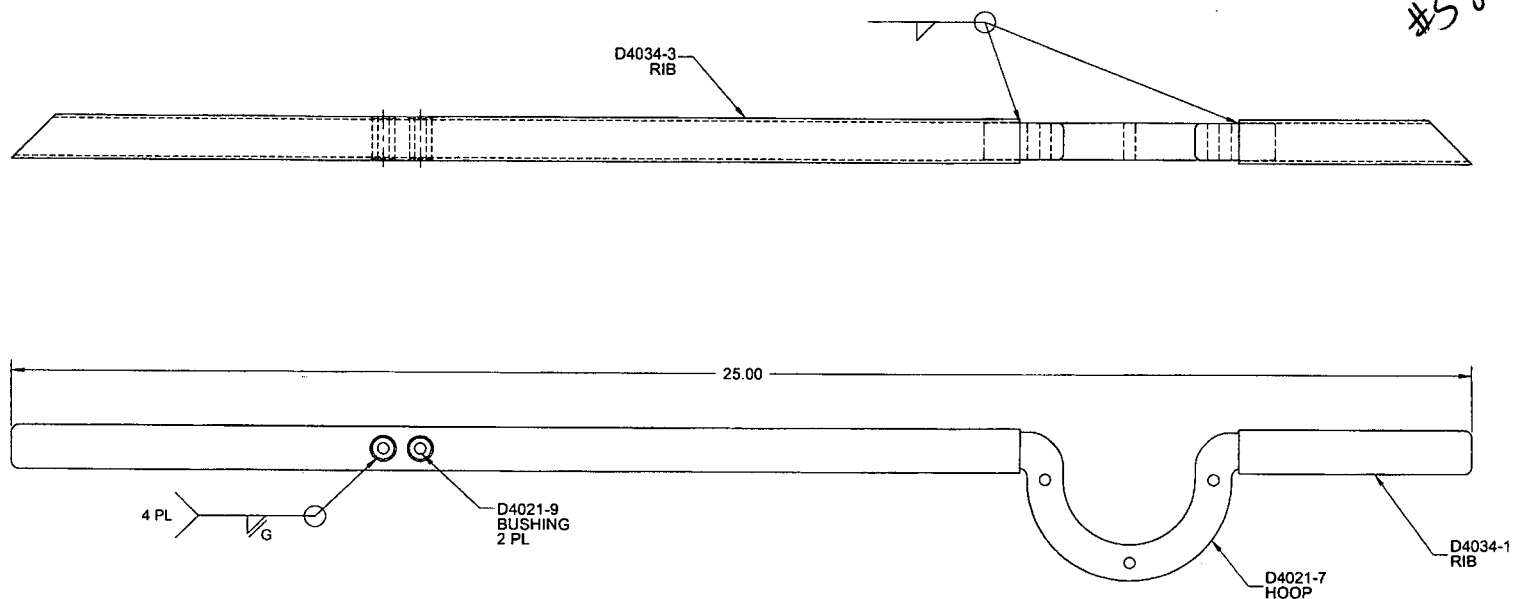
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#58040



D4034-041 AFT UPPER RIB ASSY

RELEASED
2010-03-12
M

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.59 lbs
 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	E	D4034	SHEET 2 OF 4
APPROVED	M	TITLE	SCALE
DE APPR.	M	UPPER RIB ASSY, BASKET BASE	NTS
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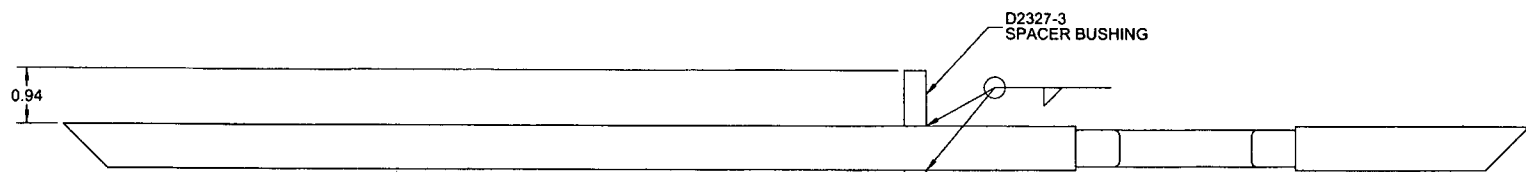
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#58040



D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
AND

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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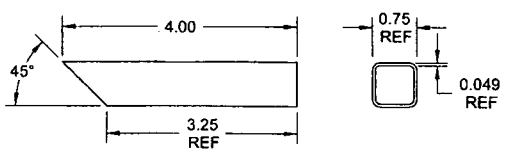
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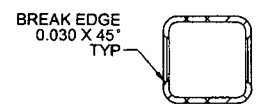
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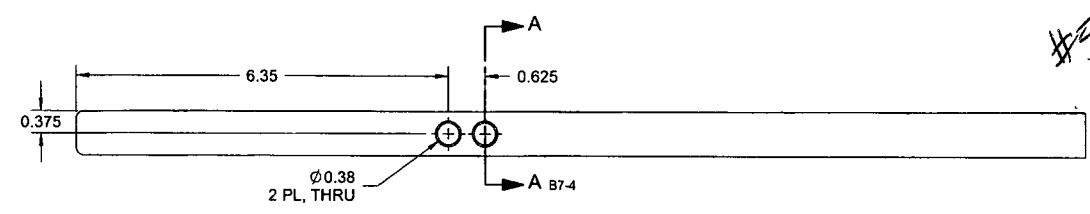
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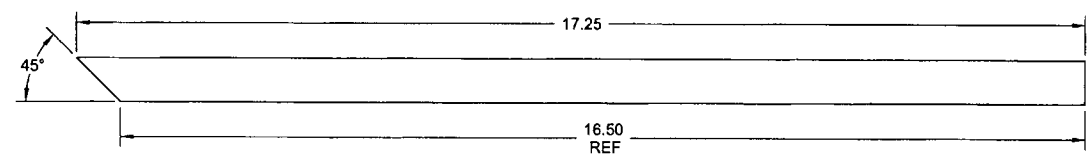
D4034-1 RIB



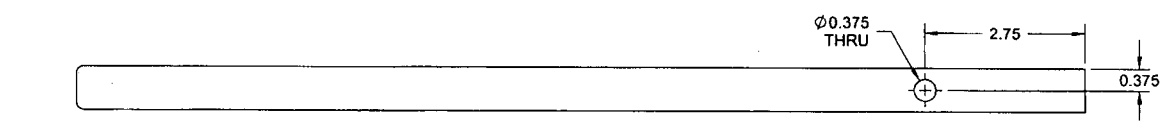
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4034	REV. A SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
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RELEASED
2010-03-12
AWP

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